

Date: Wednesday, 2/22/2006 8:48:01 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLIP
Job Number	: 25891		
Estimate Number	: 11103		
P.O. Number	: NIA	Part Number	: D30277
This Issue	: 2/22/2006 S.O. No. : NIA	Drawing Number	: D3027 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: NIA	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/22/2006 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. C 05.10.07 Added forming step and Issue P/O KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3027
 Possible Supplier: GFI
 Material release note is required

date gts
06/02/22 20
make by Rand Band
M S 2024 T3 350.50 *B 19053*

2.0	D30277F	CLIP FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 CLIP FLAT PATTERN

N/A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

N/A

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
 Inspect dimensions as per Dwg D3027

Jan 21

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary
 Form as per Dwg D3027 Dwg Rev. B

SB 06/02/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Jan 22

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/ 06 02 23 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 206/02/23 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 402*

C 206/02/23 (20)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23 (20)

Job Completion



u 06-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

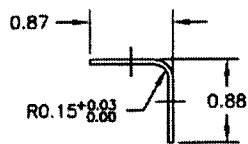
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

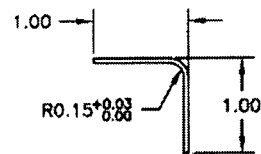
DART

DESIGN RF	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3027	REV. B SHEET 2 OF 2
DATE 05.09.20		TITLE CLIP	SCALE 1:2

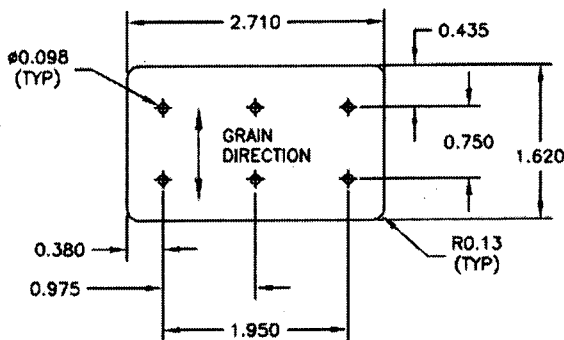
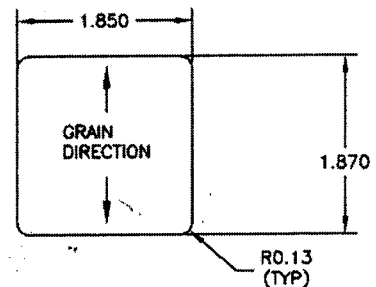
RELEASED

05.10.03 *[Signature]*

D3027-5 BEND DETAIL



D3027-7 BEND DETAIL

D3027-5 FLAT PATTERN
(0.050" SHEET)D3027-7 FLAT PATTERN
(0.050" SHEET)

REFERENCE ONLY

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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